

Work Order ID 163378

Tuesday, June 27, 2017 11:34:51 AM

163378

Page 1

Item ID: D4575-3

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 7/5/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/13/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JUL 03 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4575	A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.17

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A
Prog Rev: A

2-Deburr as required

SC 17/07/09

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.03

Quality Control

SC 17/07/09
DAS
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Work Order ID 163378

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Page 3

Item ID: D4575-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 7/5/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 7/13/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>St259</u>	0.00							
150									
Packaging	Memo	0.03							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.30							
Quality Control									

DAS
21
9-89 JUL 18 2017

Picklist Print

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Work Order ID: 163378

163378

Parent Item: D4575-3

D4575-3

Parent Item Name: Doubler

Start Date: 7/5/2017

Required Date: 7/13/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.01.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	75.5400	0.2557	0.807474			
M2024T3S 063									**		SC	17/07/09	
2024-T3 .063 sheet													

Location

Loc Qty

Loc Code

MAT

2.4

m135512

2.4

MAT009

73.14

m134640

9.14

m135612

4.6

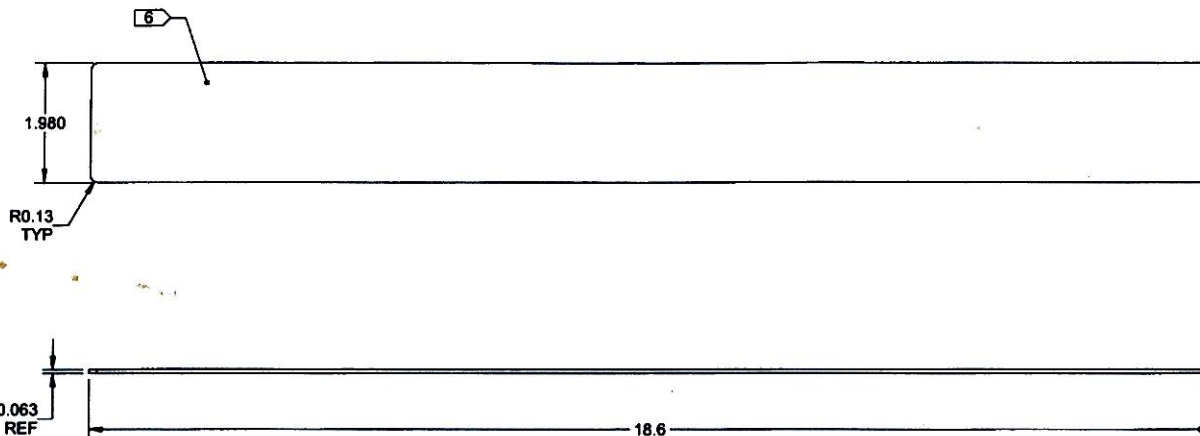
m137218

24.8

m137599

34.6

0.81



D4575-3 DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163578

ML5
170703

RELEASED
2012-01-12

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4575-3" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.22 lbs

DESIGN	163578	DART AEROSPACE LTD	
DRAWN	163578	HAWKESBURY, ONTARIO, CANADA	
CHECKED	163578	DRAWING NO.	REV. A
MFG. APPR.	163578	D4575	SHEET 3 OF 3
APPROVED	163578	TITLE	SCALE
DE APPR.	163578	REINFORCEMENT	NTS
DATE	12.01.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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